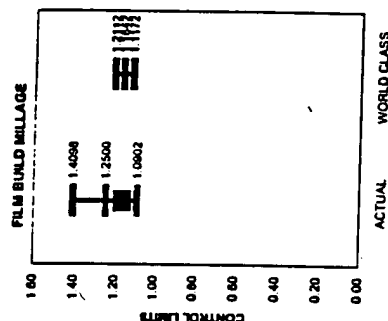


VARIATION SELECTION

- 1) Choose Variability
- 2) Select First Target Range
- 3) Average Adjusted to World Class Standard

Coating: Black Prime	Coating Min. Spec.:	0.9
Panel: Hood	Actual Average:	1.25
Booth: na	Actual Range:	0.68
	Actual Cpk:	0.587
	Subgroup Size:	14
	Target Range:	0.2
	World Class Cpk:	1.5

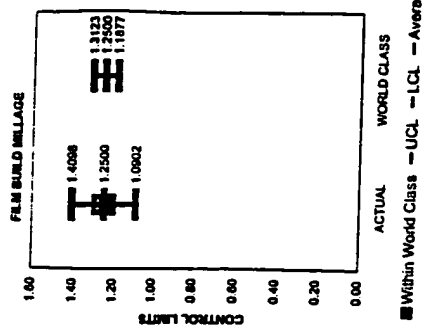


■ Within World Class — UCL — LCL — Average

VARIATION REDUCTION

- 1) Variability Adjusted to World Class Standard
- 2) Costing Usage Remains Consistent
- 3) Average Remains Constant

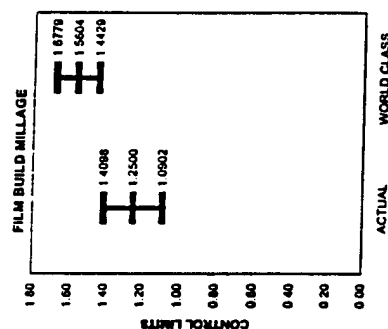
Coating: Black Prime	Coating Min. Spec.:	0.9
Panel: Hood	Actual Average:	1.25
Booth: na	Actual Range:	0.68
	Actual Cpt:	0.587
	Subgroup Size:	14
	New Range:	0.27
	World Class Cpt:	1.5



VARIATION SELECTION

- 1) Choose Variability
- 2) Select Second Target Range
- 3) Average Adjusted to World Class Standard

Coating: Black Prime	
Panel: Hood	
Booth: na	
Coating Min. Spec.:	0.9
Actual Average:	1.25
Actual Range:	0.68
Actual Cpt:	0.587
Subgroup Size:	14
Target Range:	0.5
World Class Cpt:	1.5



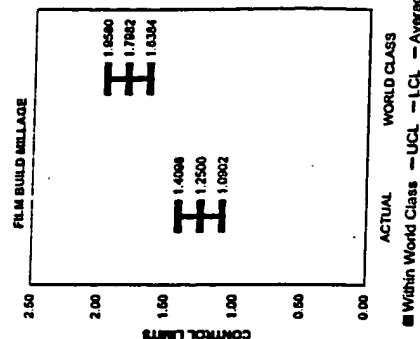
ACTUAL **WORLD CLASS**

■ Within World Class — UCL — LCL — Average

INCREASED MILLAGE

- 1) Coating Usage Increases
- 2) Variability Remains Constant
- 3) Average Adjusted to World Class Standard

Coating: Black Prime	
Penet: Hood	
Booth: na	
Coating Min. Spec.:	0.9
Actual Average:	1.25
Actual Range:	0.68
Actual Cpk:	0.567
Subgroup Size:	14
New Average:	1.7912
World Class Cpk:	1.5



Cost per Unit Factors:							
Coating: Black Prime	Panel: Hood	Usage per Unit (gal.): 0.27	Cost per Gallon (\$): 27	Coating Popularity %: 25	Panel %: 15	Booth % Flow: 100	Annualized Production (units) 200,000